

PROJECT TITLE : SPECIFICATIONS / PROCESS ASSURANCE

Period Covered : 25.12.1980 - 27.1.1981

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0. SPECIFICATIONS - OVERALL

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1. SPECIFICATIONS PER PRODUCTION CENTER PME

1.1 FTR Neuchâtel

- The cigarette making specifications for Marlboros and Merits have been modified to comply with the standard tobacco weights and AccuRay limits set forth for the three months' test (1.1. - 31.3.1981). (Reference 1)

1.2 INM SpA Zola Predosa

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1.3 PMH Bergen op Zoom/Eindhoven

- Cigarette making specs Marlboros as per FTR, point 1.1 above.

1.4 PMG Munich/Berlin

- Cigarette making specs Marlboros and Merits as per FTR, point 1.1 above.

1.5 WELTAB Bruxelles

- Cigarette making specs Marlboro and Merit as per FTR, point 1.1 above.
- A new product version of Merit, MER 059, for sale in Luxemburg, has been introduced.
- The tow weight of the 100 mm Merit filter has been increased, to meet the RTD increased last year.

1.6 PM UK London

1.7 PM Nigeria, Ilorin

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1.8 Licensees

- Poland:  
The complete spec file for Marlboro King Size, Poland, is being reviewed.

2. MATERIAL SPECIFICATIONS

2.1 Approvals by suppliers

The firm I.C.I., Zurich, has approved the material specs for their Propafilms C 23 and MTX 22.

2.2 Submissions to suppliers

PME material specs have been submitted for/to:

- |                                   |                    |
|-----------------------------------|--------------------|
| - Cig. paper TERCIG H 10 DIN 60   | Tervakosky         |
| - Cig. paper TERCIG O 8,5 ND 4321 | Tervakosky         |
| - Cig. paper Pela 200/09 Velin    | Schoeller & Hoesch |
| - Tipping paper Acquafuge 944 BNG | Malaucène          |

2.3 Special work

- A meeting was held in Neuchâtel to clarify and define the situation regarding the qualities, suppliers, and the usage of films (cellophanes and polypropylenes).
- The new cigarette paper TERCIG O 8,5 ND 4321 is accepted for MLL Marlboro Lights, produced with ATO Finland. - It is refused for MLF Marlboro Filter, manufactured at the same production center.

After confirmation by Panel A, it may be used in Eastern European countries, in the future.

3. PME STANDARD RECIPES

- The composition of solution BEM-PC (ATO Finland) has changed.
- Corrections regarding the usage of several solutions used by Ed. Laurens BV, The Hague, have been applied.

4. SPECIFICATIONS ON EDP

About 5 working days were spent on the above project, together with C. Cotting, EDP FTR, on the one hand,

and MM. M. Davis and D. Magil on the other hand. In a first phase, the business situation and functions of SOPA (Specs Office and Process Assurance) have been outlined.

Following the review session of January 21, 1981, detailed analysis and evaluation (functions, tools, information requirements, system concept) are being defined in cooperation with E. Grossen, QA manager FTR, as a representative for the production centers' QA managements.

Another review session with the PME EDP representatives is planned for end February, 1981

## 5. PROCESS ASSURANCE

### 5.1 AccuRay

Following the decision to carry out a 3 months' industrial trial with standard tobacco weights and AccuRay settings for Marlboro and Merit cigarettes, as from 1.1.1981, the situation is the following in the various production centers:

#### FTR

The new limits were introduced end December, 1980. No problems.

#### PMG Munich

No problems.

#### PMH

A first trial with the new limits was made on 5 machines.

Results:

- tobacco savings about 2 %
- compressibility about 4,0 mm
- compressibility on the other machines about 3,8 mm
- practically no problems regarding light weight rejects, loose ends, and rejects at the packers.

#### WELTAB

The new limits were introduced mid-January only. End January 1981, there still existed some problems regarding the calibration of the C 1700 units. - As a consequence, the results of January cannot be considered in the test evaluation.

5.2 NTM Non-tobacco Material Weights (Reference 2)

- A detailed report has been addressed to FTR Cousset regarding the trials to be realised.
- Determination of quantity of glue on tipping paper: We are still waiting for the Munich and Berlin results.

5.9 Tobacco Weights

All production centers have adapted their specifications (see also AccuRay), except PMH.

5.13 Production Diana, MTI Lecce IT

In December, 1980, taste problems turned up when a trial production was made, with a blend containing new blocs of tobacco. In the following, a PME delegation assisted at another trial production in Lecce, as well as at the start of production in January. The cigarettes were smoked and approved on site.

Samples of all supply materials, ingredients, and solutions, were brought back from Lecce for a complete quality check in the PME labs in Neuchâtel.

5.14 ETNA Specifications

A new provisional spec has been prepared for ETNA, flue-cured type. A unique spec will be produced in future, covering the sections

- processing of the tobacco
- process for expanded tobacco

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References

1. Standard tobacco weight and AccuRay limits. Memo T. Bel to QA managers, 5.12.1980
2. Report to Mr R. Jaquet, FTR Cousset, regarding NTM trials, dated 6.1.1981.